

Derev 55843

Work Order ID 53041



Page 1

October 22, 2009 10:52:37 AM

Item ID: D3155-041
Revision ID: D
Item Name: Bracket Assembly

Accept



Setup Start



Stop



Start Date: 21/10/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals:

Process Plan: *PL*

Date: *09-10-22*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3155

Rev D

100

0.00



BAND SAW

Bandsaw

Memo

0.00

mmf 09/11/13

8

0

Jeaspa Bandsaw

Cut blanks: (2.000" x 1.000") x 6.87" Long Bar

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

H.A 09/11/13

HA

HAAS CNC vertical machine #1

1-Machine as per Folio FA315 and Dwg D3155-2-Deburr and Tumble-3-Identify as D3155-1

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

H.A 09/11/13

HA

Quality Control

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3155-041 PAR #: _____ Fault Category: Machined parts NCR: Yes No DQA: 1 Date: 10-02-10
 Resolution: ^A scrap / ^B the / ^C accepted / re-work Disposition: ^A scrap / ^B use as is / ^C re-work QA: N/C Closed: 1 Date: 10/02/11

NCR: 53041		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/11/14	110	1 part Scrap during prog#3001 to the Spacer got stuck during finishing of the outside profiling and broke the dowel pin, causing Ø.375" hole to be out of tol.	CP 09.11.16 JW QSI 042	Made 1 new Spacer Scrap and replace B# 112567	DJA 09/11/14	S 10/02/01	CP 09.11.16 JW QSI 042	S 10/02/01
09/11/14	110 R.C.	3 parts dim 0.163" and 0.158" are out of tol. Programme error	CP 09.11.16 JW QSI 042	Insert new offsets in Program Between 0.003-0.005" out of tol. Acceptable	DJA 09/11/14	S 10/02/01	CP 09.11.16 JW QSI 042	S 10/02/01
10/02/01	#170	Found during inspection 04 x 5 Parts with markings from Press- fit in bushes R.C. Press Plunger too close to part	CP 10/02/01	Build out to toler and Blend in marks. Touch-up with machine per Casi 005	CP 10/02/01	S 10/02/01	CP 10/02/01	S 10/02/01

NOTE: Date & initial all entries Human error

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Cust Item ID:
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Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC21- Final Inspection - Work Order Release <i>QC8</i> Memo	0.00 0.00	<i>Jul/09-11-16</i>				_____	_____	_____
140 QC Quality Control	QC5- Inspect part completeness to step on W/O <i>N/A</i> Memo	0.00 0.00					_____	_____	_____
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	<i>7/21 02/11/12</i>				<i>(11x)</i>	<i>0</i>	_____

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Setup Start



Stop



Start Date: 21/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

GS 10/02/01 (11)

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Press fit bushing as per Dwg D3155

GS 10/02/01 (11)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 S 10/02/01

(11)

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Required Date: 30/10/2009 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Packaging	Identify as per dwg & Stock Location: <u>29</u> Memo	0.00 0.00							<u>Per 4/3</u> <u>(11)</u>
200 QC Quality Control	QC21 - Final Inspection - Work Order Release Memo	0.00 0.00							<u>10/02/03</u> <u>MF</u> <u>10-2-3</u>

Picklist Print

October 22, 2009 10:52:42 AM

Page 1

Work Order ID: 53041

Parent Item: D3155-041RevD

Parent Item Name: Bracket Assembly

Comments:

Start Date: 21/10/2009

Required Date: 30/10/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3155-3RevD

Manufactured

No

100

Each

10.0000

8.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST68

10

50543

10

170

f

84.0545

2.4560

M6061T6B1.000X02.00
0

Purchased

No



6061-T6 Bar 1.00 x 2.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

84.0545

107129

7.03

111571

19.3575

112567

57.667

EP 10/02/01
B53813 *(12+)*

10

4.844

mt
09/11/13 (x8 piece)

D3065-5DART AEROSPACE LTD		Work Order:	53041
Description: Bracket		Part Number:	D3155-1
Inspection Dwg: D3155 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.166	+0.005/-0.001	Ø0.167	✓			
Ø0.375	+0.000/-0.005	Ø0.375	✓			
6.150	+/-0.010	6.150	✓			
0.262	+/-0.010	0.262	✓			
1.400	+/-0.010	1.399	✓			
0.307	+/-0.010	0.313	✓			
1.969	+/-0.010	1.970	✓			
0.322	+/-0.010	0.322	✓			
0.779	+/-0.010	0.774	✓			
0.166	+/-0.010	0.169	✓			
0.307	+/-0.010	0.313	✓			
1.300	+/-0.010	1.3065	✓			
0.130	+/-0.010	0.125	✓			
0.150	+/-0.010	0.148	✓			
0.150	+/-0.010	0.155	✓			
0.853	+/-0.010	0.852	✓			
0.163	+/-0.010	0.159	✓			
R0.063	+/-0.010	R0.063	✓			
5.455	+/-0.010	5.456	✓			
4.400 → 4.400	+/-0.010	4.395	✓			
2.060	+/-0.010	2.060	✓			
0.021	+/-0.010	0.022	✓			

Measured by:	H.A
Date:	09/12/13

Audited by:	[Signature]
Date:	09-11-16

Prototype Approval:	N/A
Date:	N/A

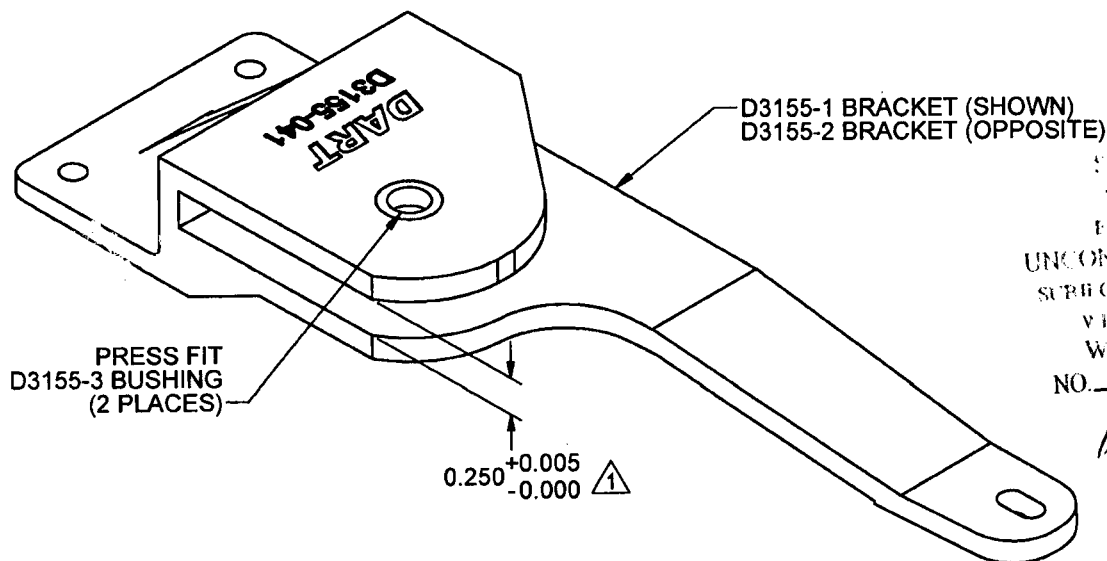
Rev	Date	Change	Revised by	Approved
A	06.06.28	New Issue P/O D3155-041	KJ/JLM	[Signature]



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3155	REV. D SHEET 1 OF 3
DATE 07.01.18		TITLE BRACKET ASSEMBLY	SCALE 1:1
REV	DATE	DESCRIPTION	
A	02.04.24	NEW ISSUE	
B	03.02.28	AS MANUFACTURED	
C	04.10.06	5.455 WAS 5.550	
D	07.01.18	ON D3155-1/-2, 0.699 DIM WAS REMOVED; 0.887 WAS 0.882; 3.150 WAS 3.148; ADD 0.250 DIM +0.005/-0.000	

RELEASED

07.01.18 [Signature]



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PA 09-10-22

D3155-041 BRACKET ASSEMBLY
(SHOWN, REPLACE PREMIER P/N B30-23000-11)
D3155-042 BRACKET ASSEMBLY
(OPPOSITE, REPLACES PREMIER P/N B30-23000-12)

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3155-041	BRACKET ASSEMBLY
	X	D3155-042	BRACKET ASSEMBLY
1		D3155-1	BRACKET
	1	D3155-2	BRACKET
2	2	D3155-3	BUSHING

NOTE:

1 MAINTAIN THE $0.250^{+0.005}_{-0.000}$ DIMENSION AFTER PRESS FITTING THE BUSHING.

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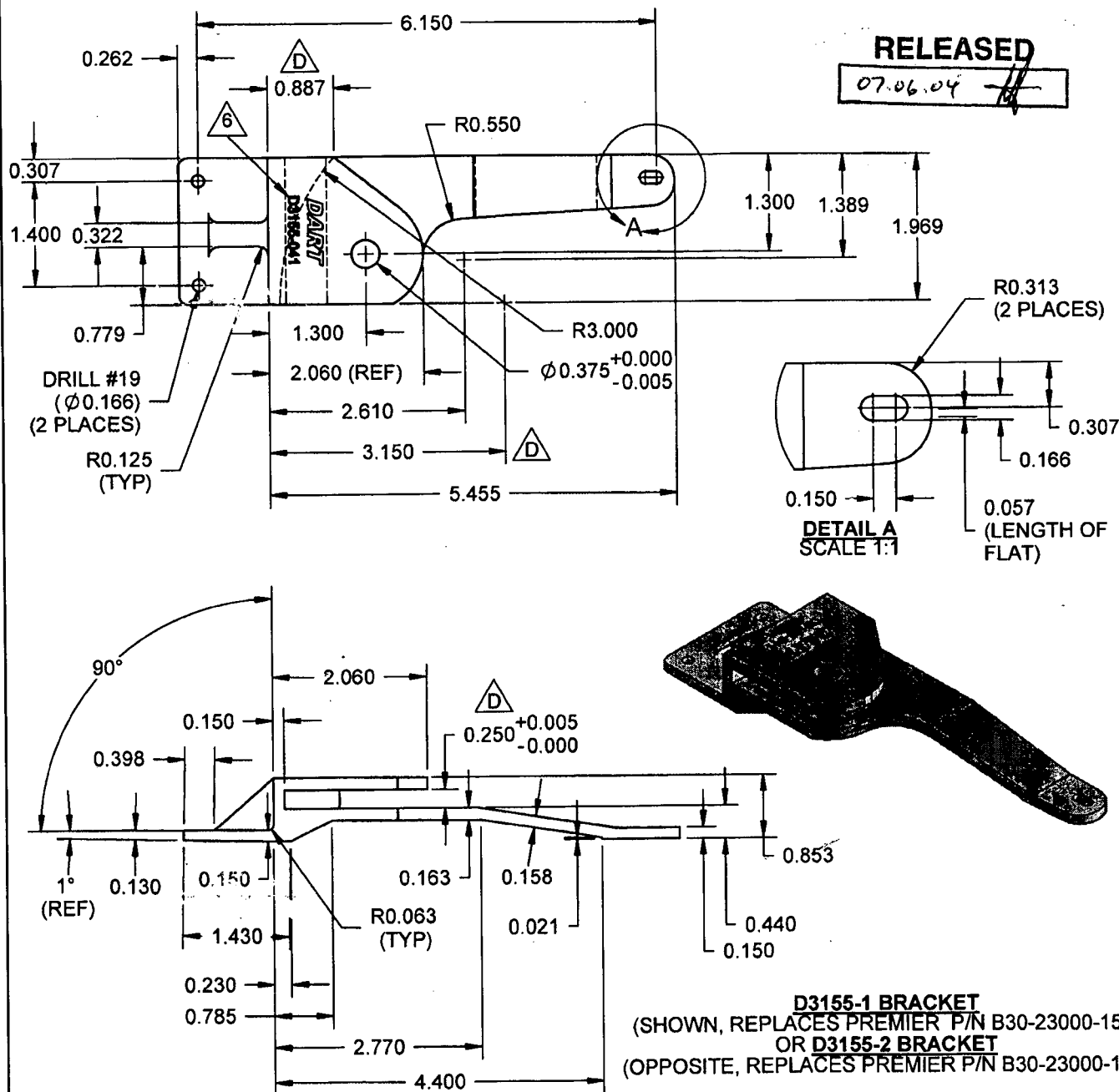
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 WORK ORDER



53041

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3155	REV. D SHEET 2 OF 3
DATE 07.01.18	TITLE BRACKET ASSEMBLY		SCALE 1:2



NOTES:

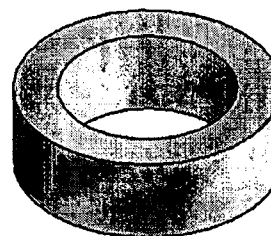
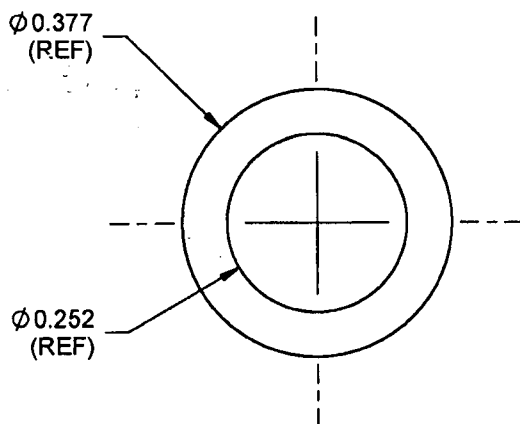
- 1) MATERIAL: ALUMINUM BAR 6061-T6/-T651 PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117 OR AMS 4128 OR AMS 4115 OR AMS 4116 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO AS SHOWN TO MAX DEPTH OF 0.010 WITH A MIN RAD OF 0.010

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DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>CH</i>	DRAWING NO. D3155	REV. D SHEET 3 OF 3
DATE 07.01.18		TITLE BRACKET ASSEMBLY	SCALE 4:1



RELEASED

07.06.04 *CH*

SHOWN
REVIEW
ENGINEER
UNCONTROLLED
SUBJECT
WITH
W
NO. *530411*

D3155-3 BUSHING

NOTES:

- 1) MATERIAL: MAKE FROM SBS-3-3 (SOLID BAR) OR SS-812-20 (TUBING)
POSSIBLE SUPPLIER: SYMMCO
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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